

FIGURE 1

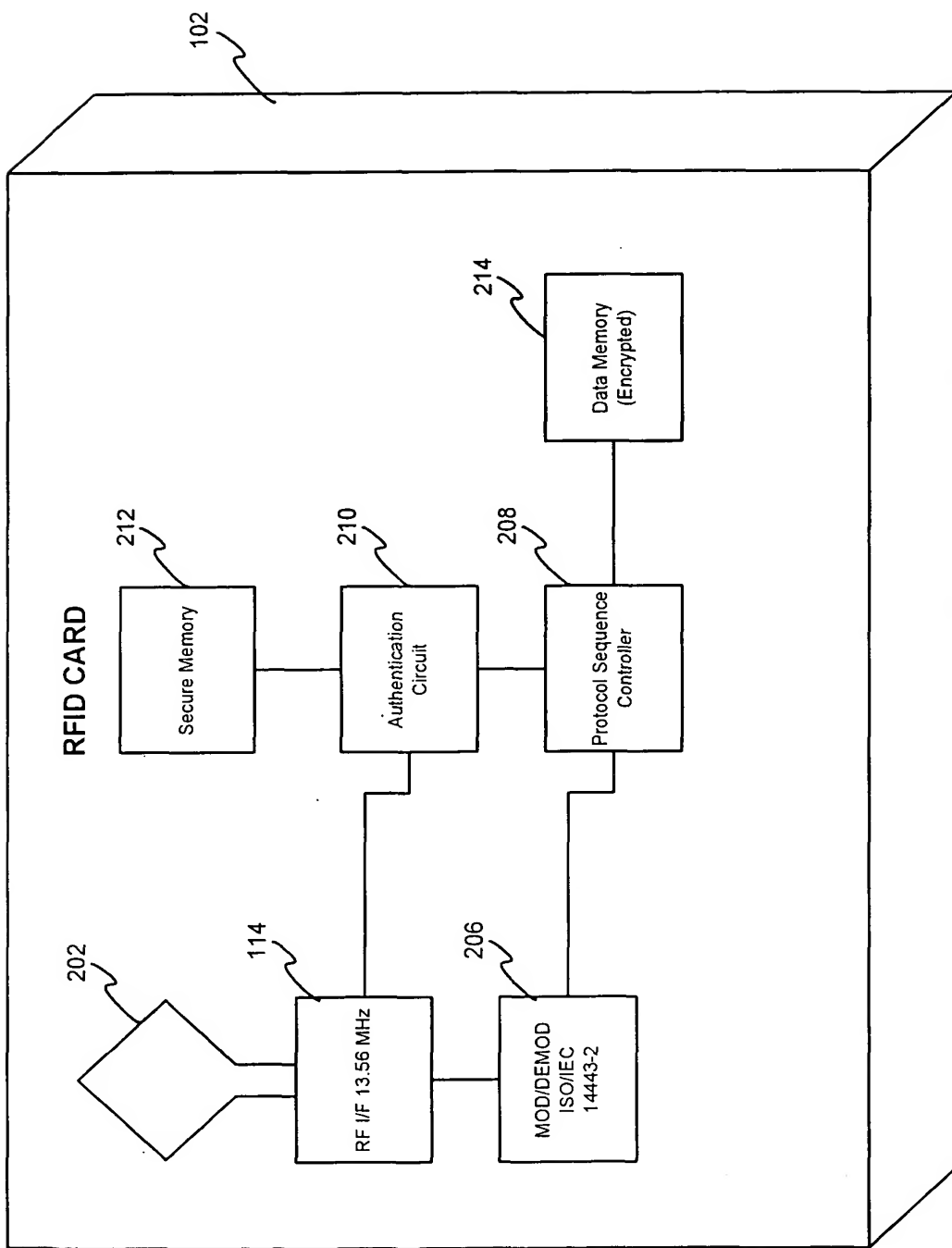


FIGURE 2

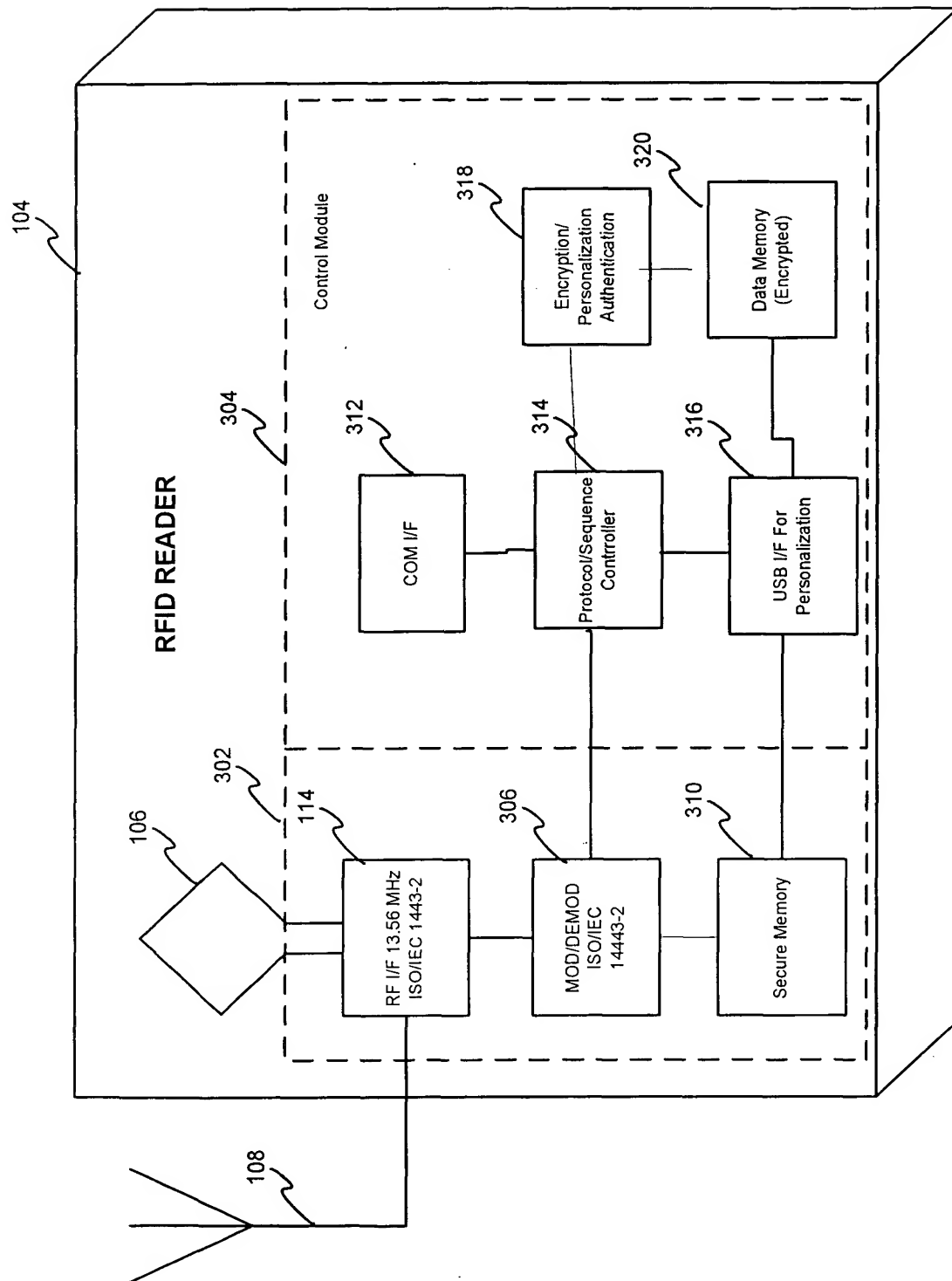


FIGURE 3

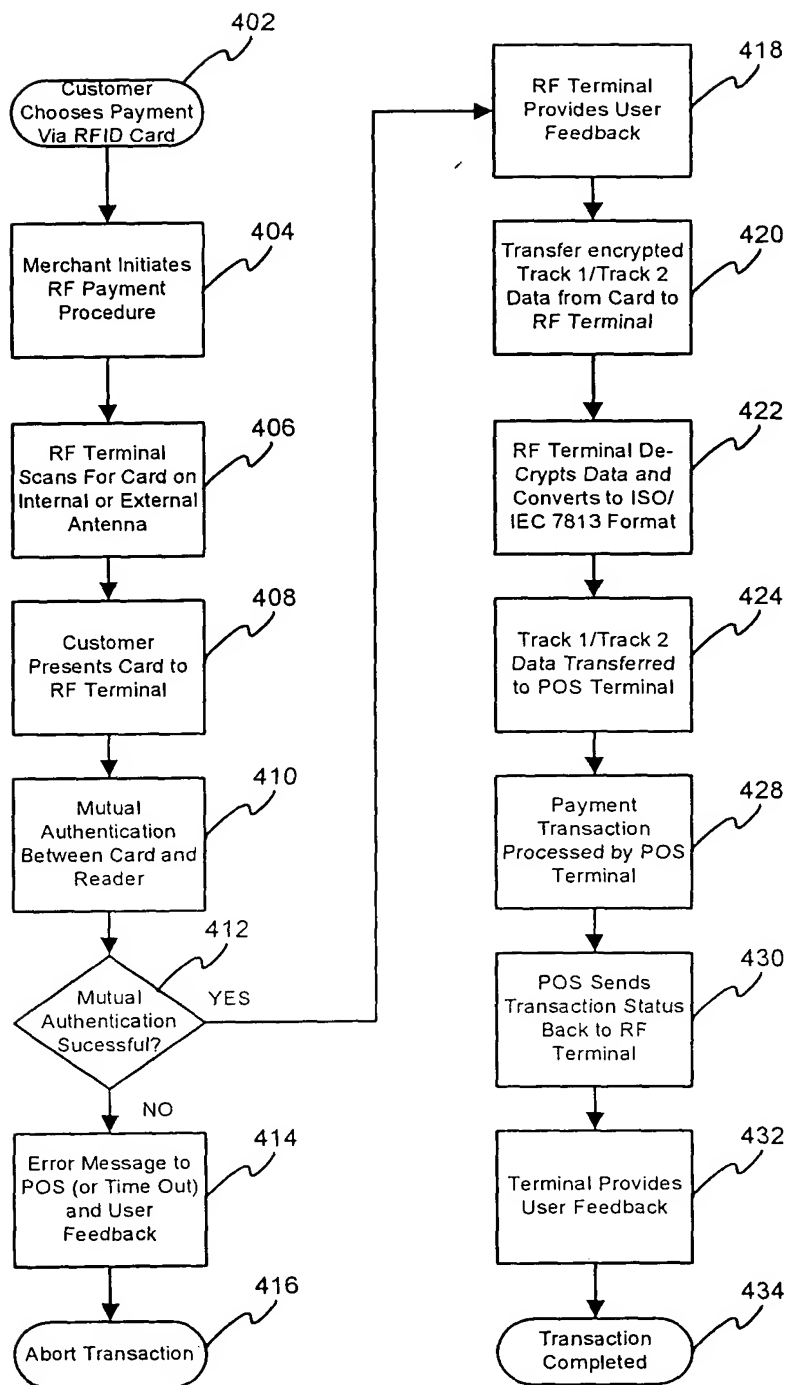


FIGURE 4

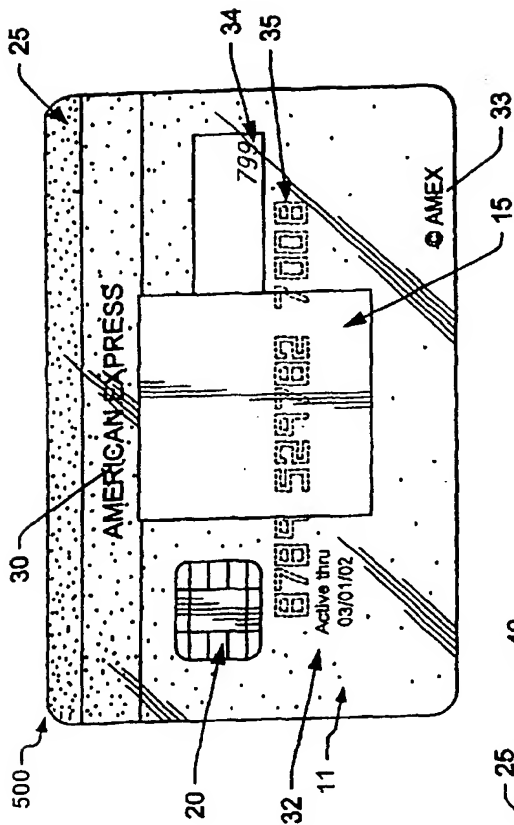


FIGURE 5

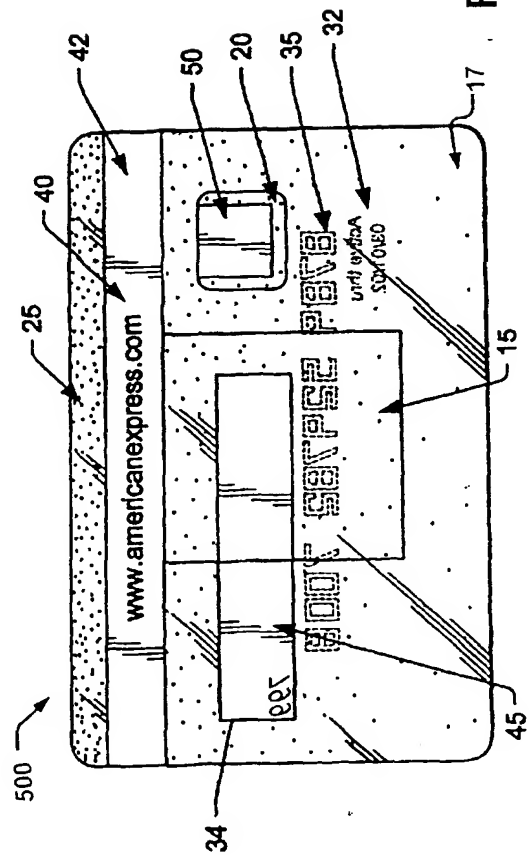


FIGURE 6

QA IR Screen

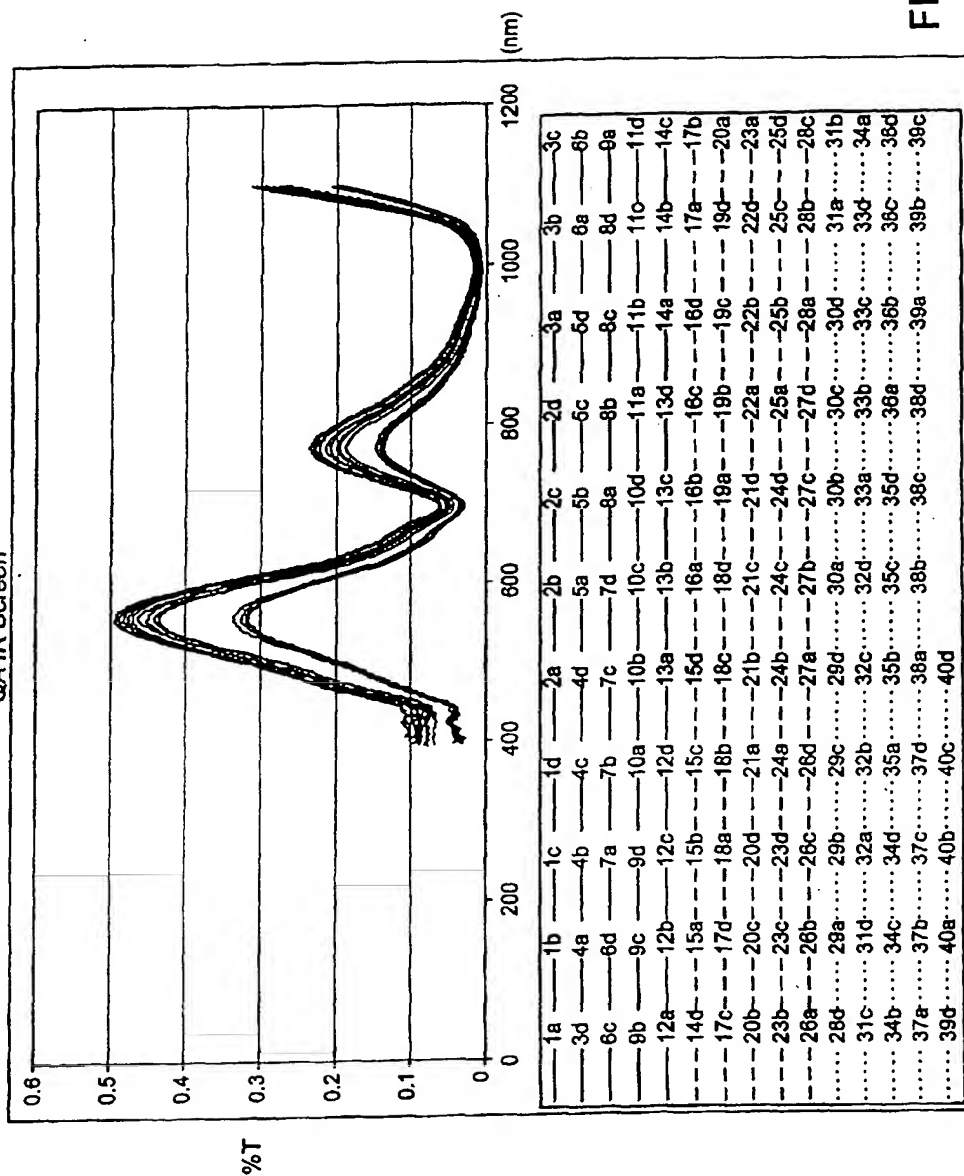


FIGURE 7A

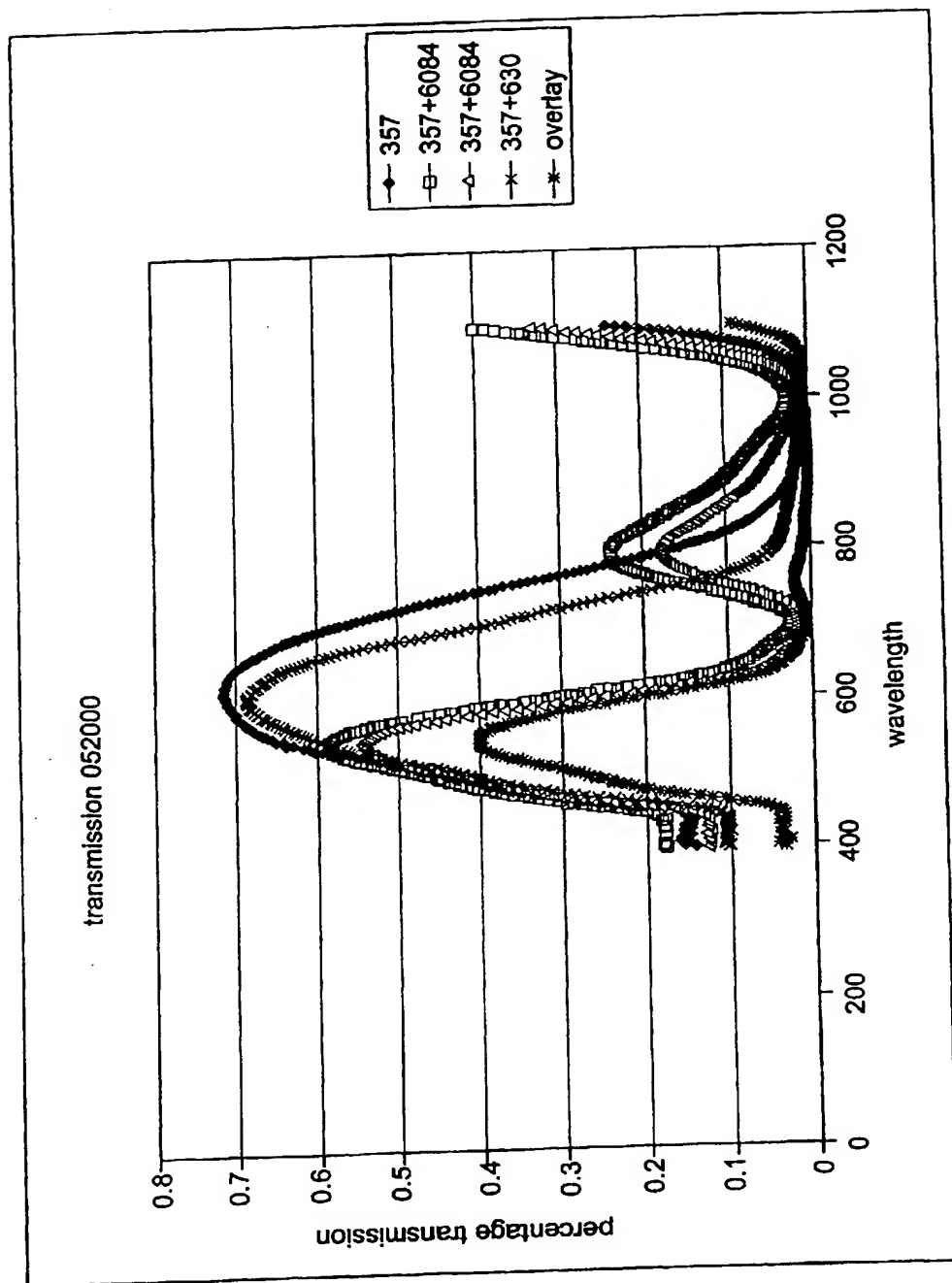


FIGURE 7B

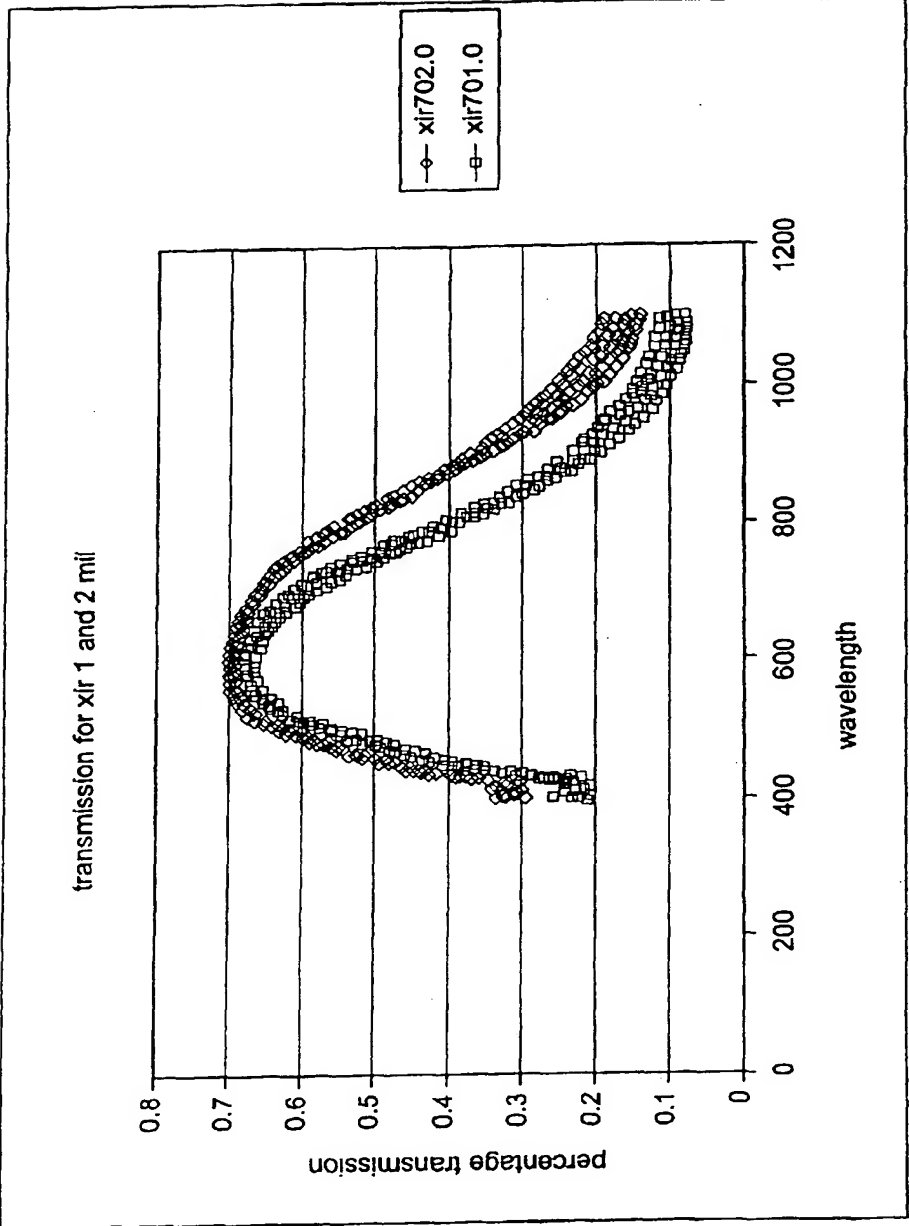


FIGURE 7C

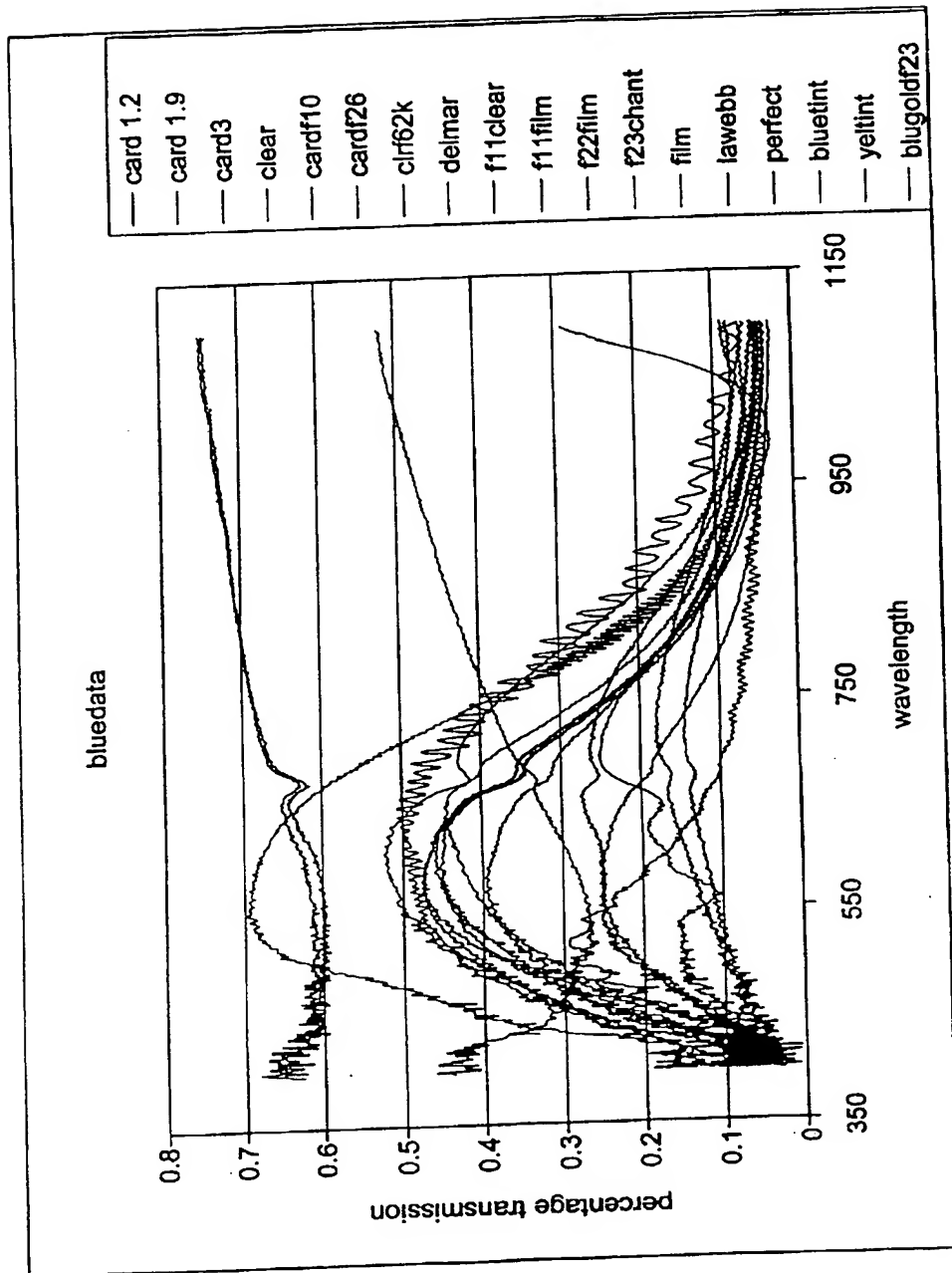


FIGURE 7D

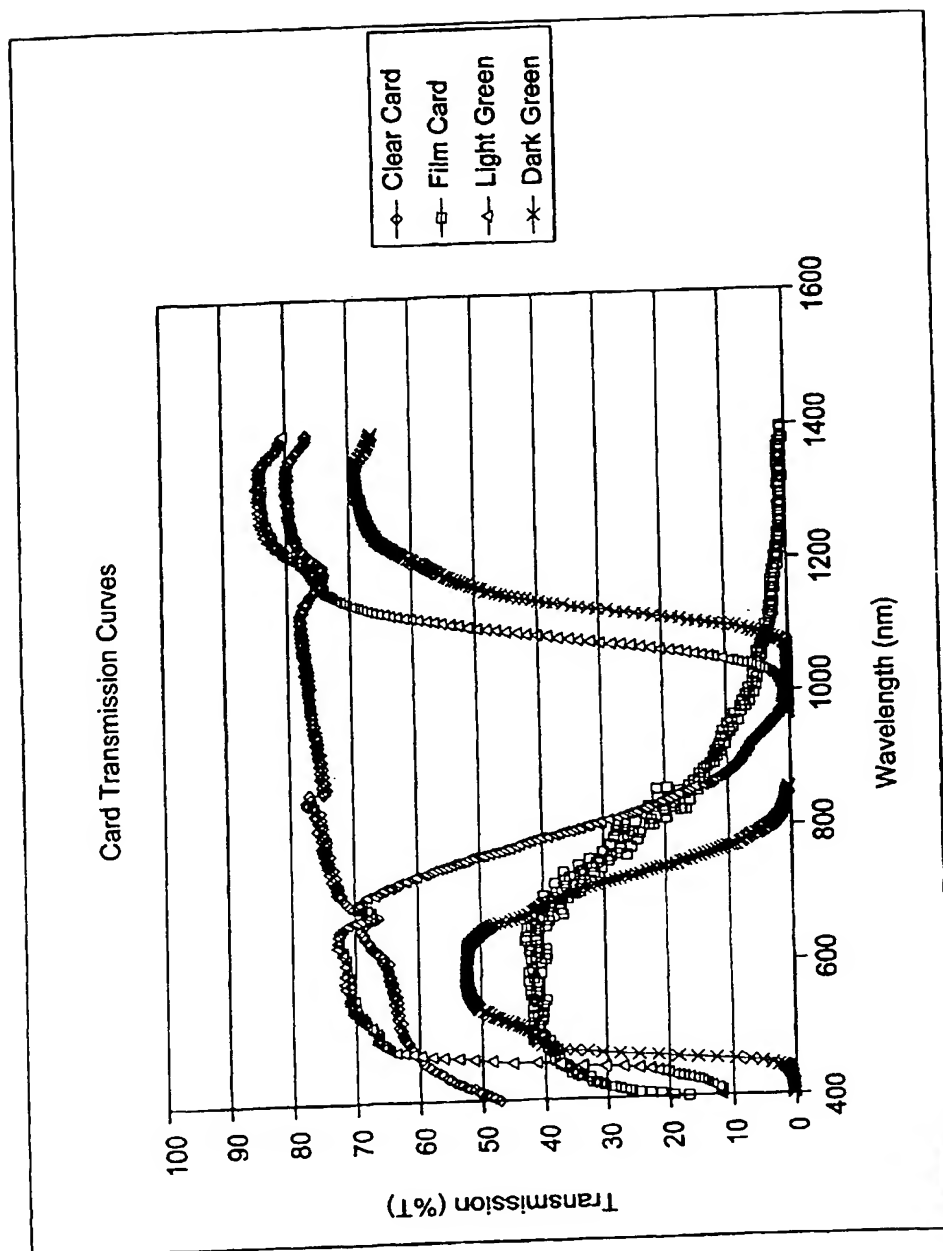


FIGURE 7E

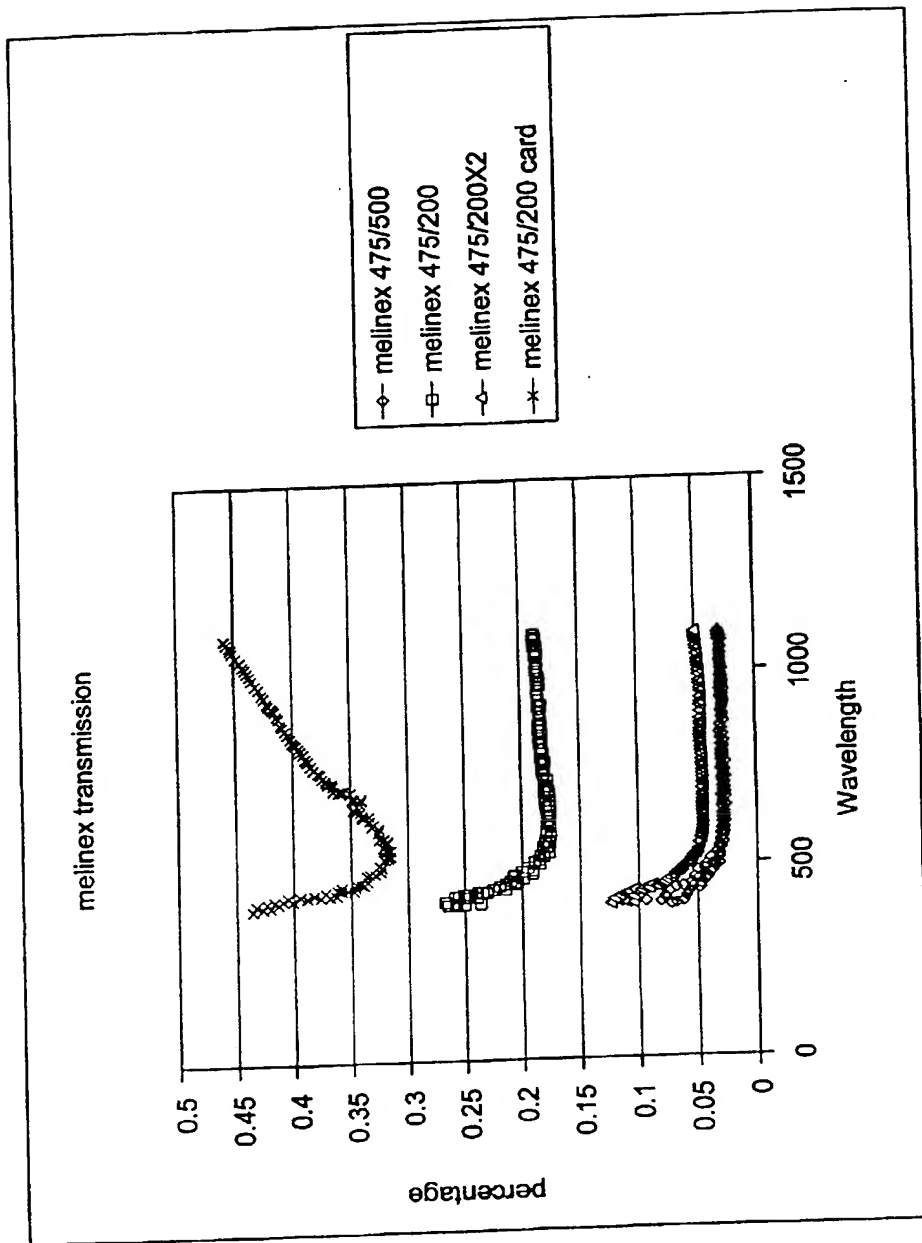


FIGURE 7F

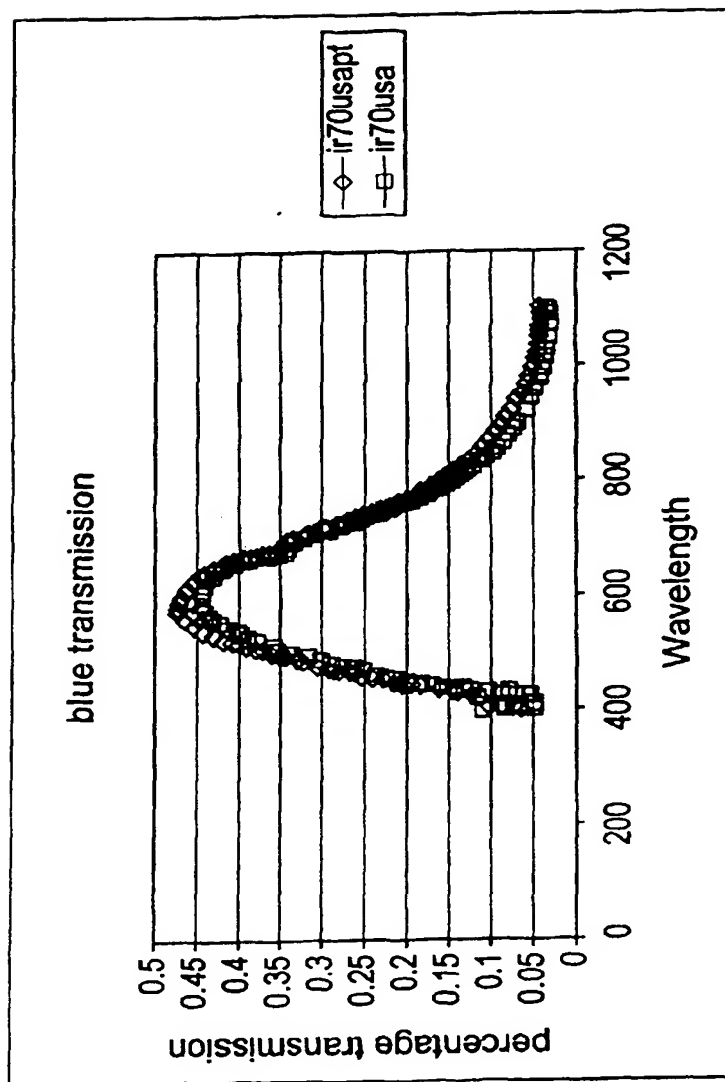


FIGURE 7G

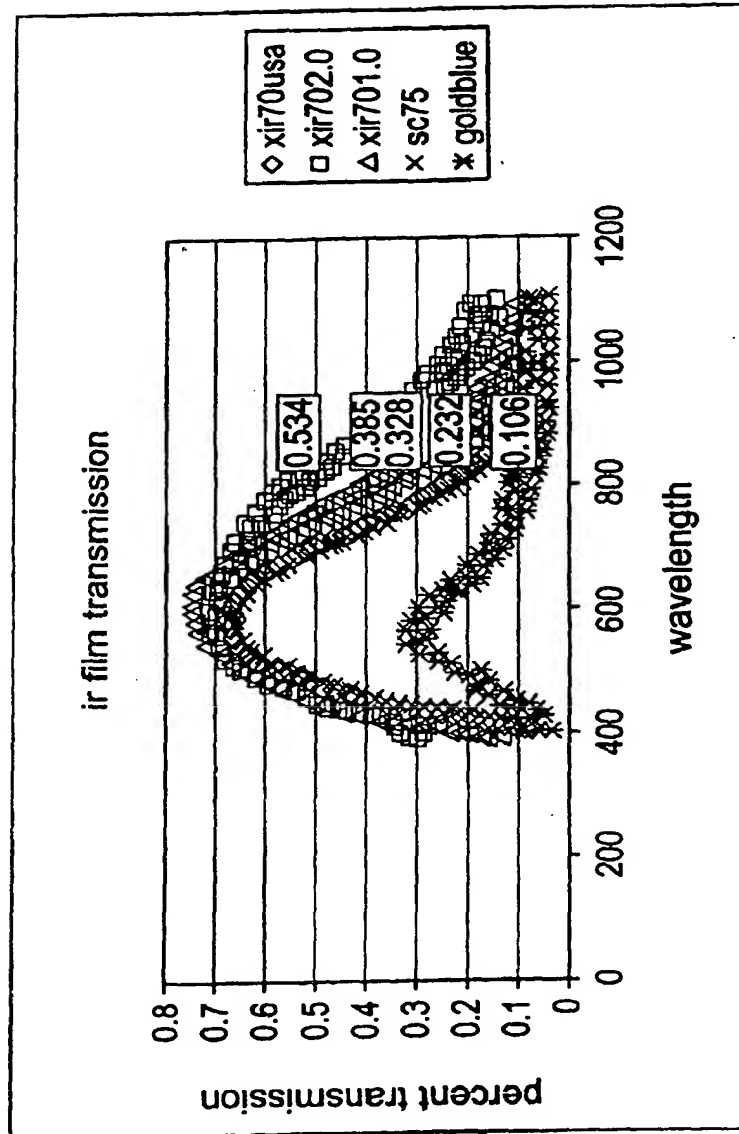


FIGURE 7H

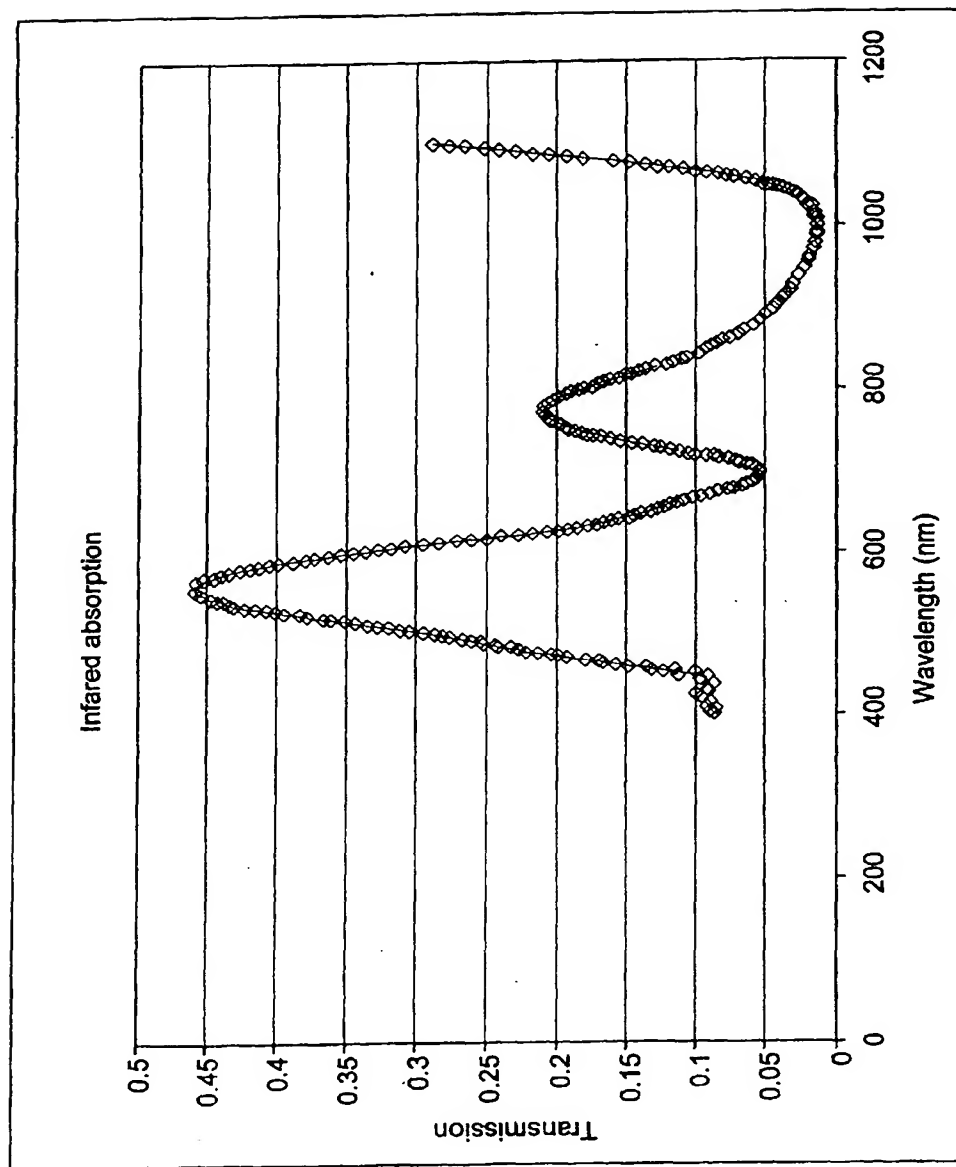


FIGURE 71

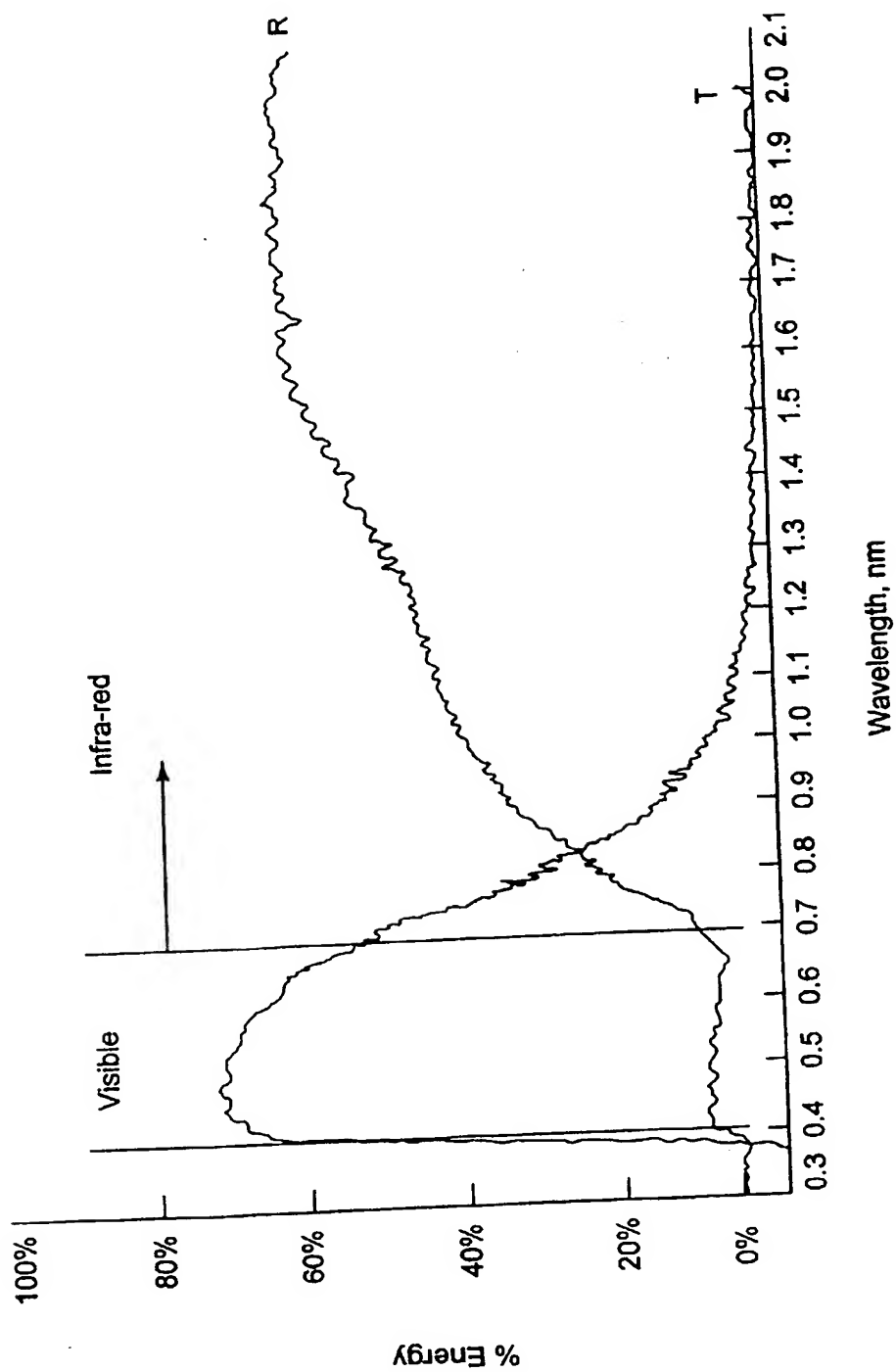


FIGURE 8

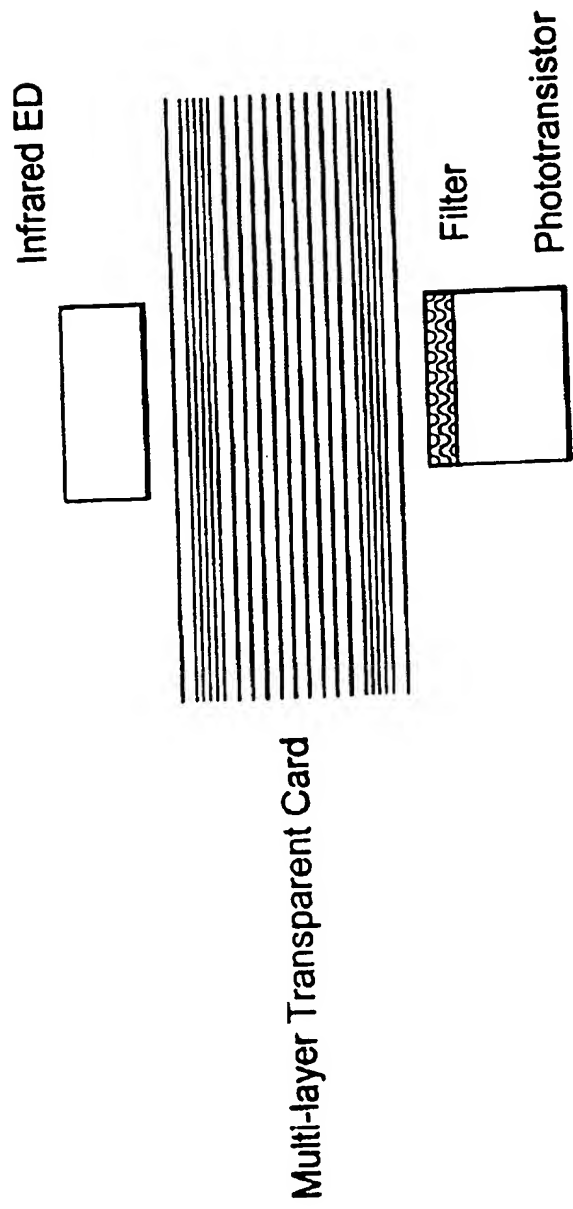


FIGURE 9

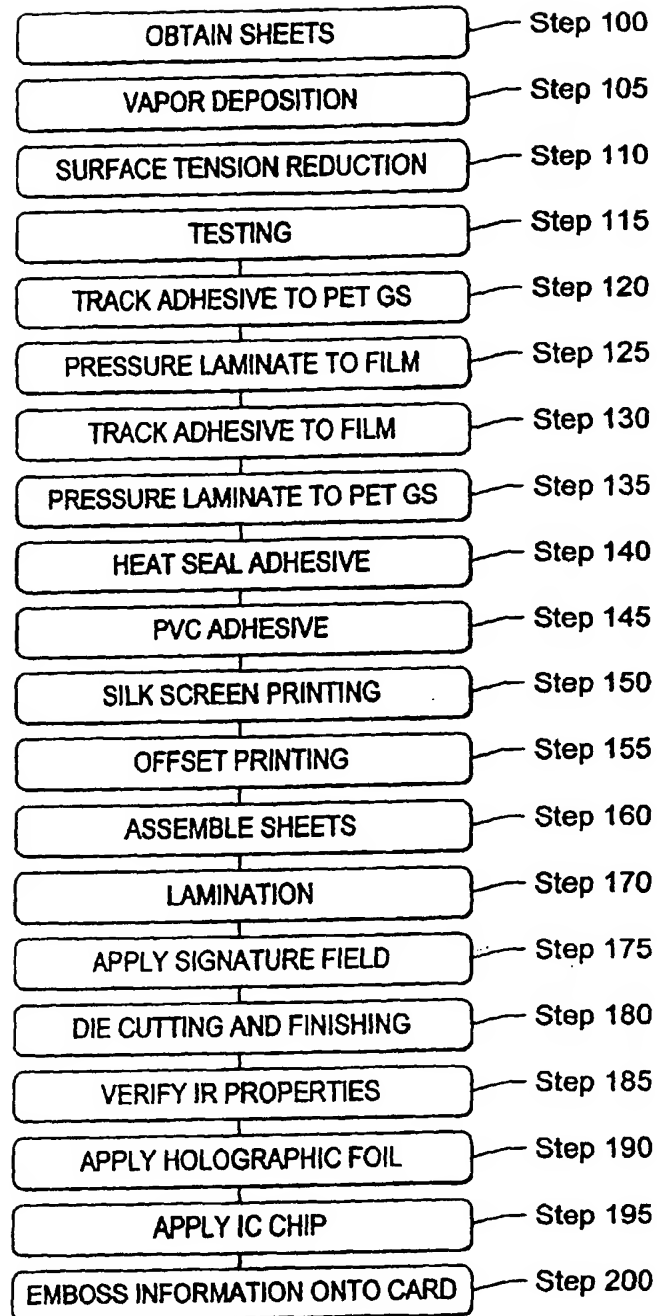
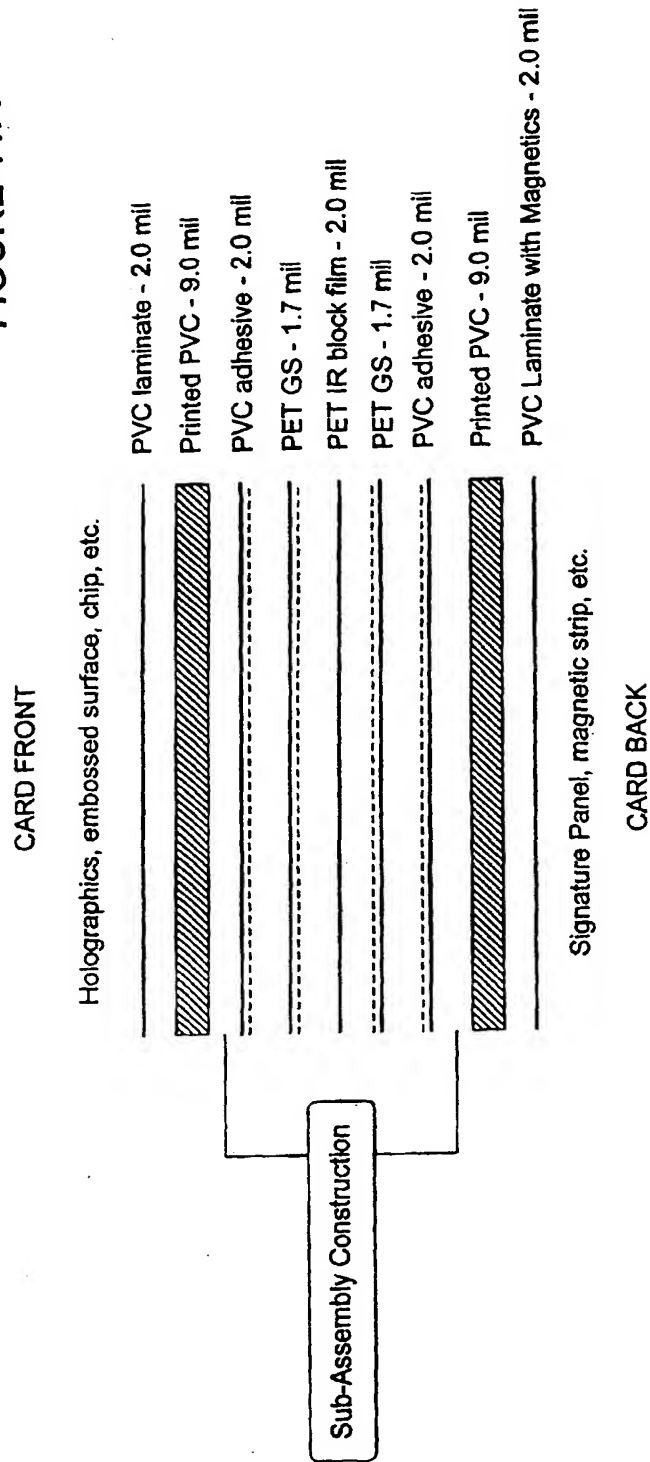


FIGURE 10

FIGURE 11A



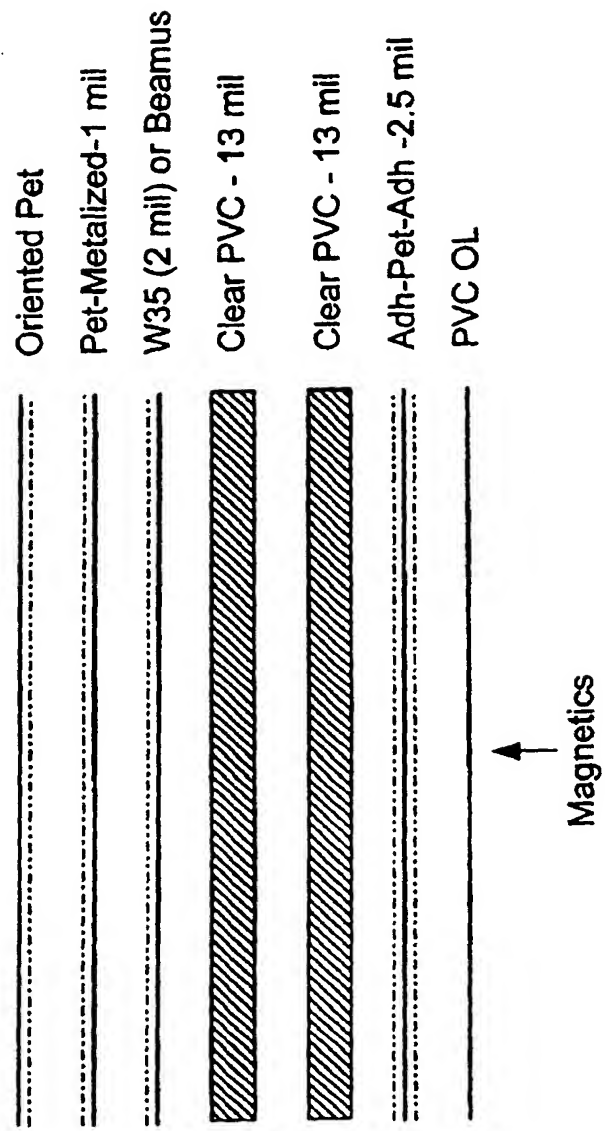


FIGURE 11B

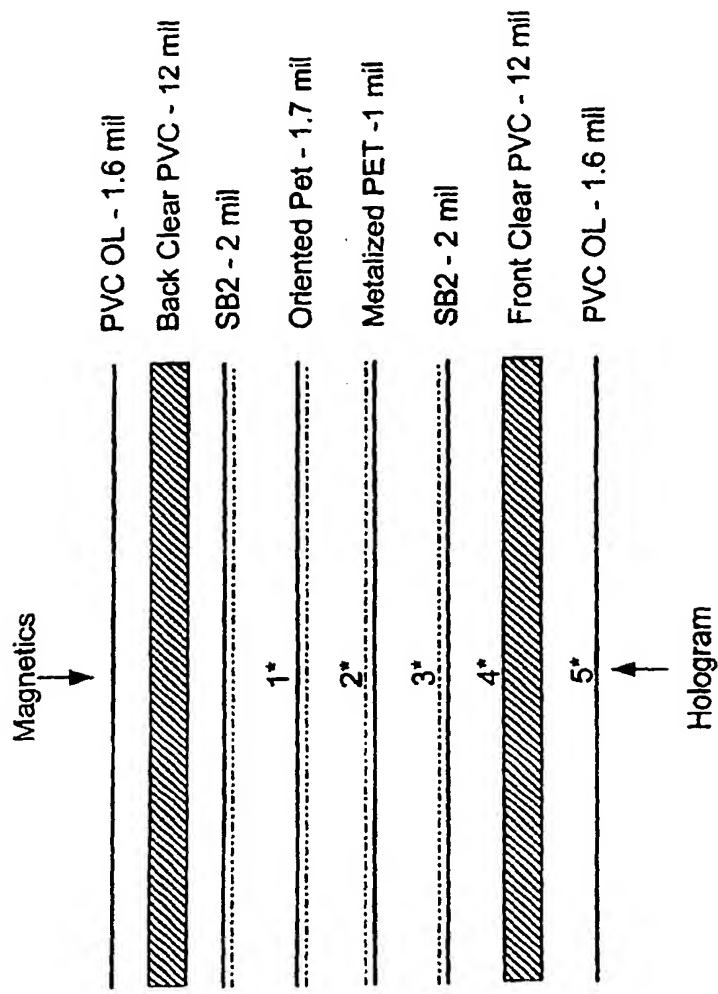


FIGURE 11C

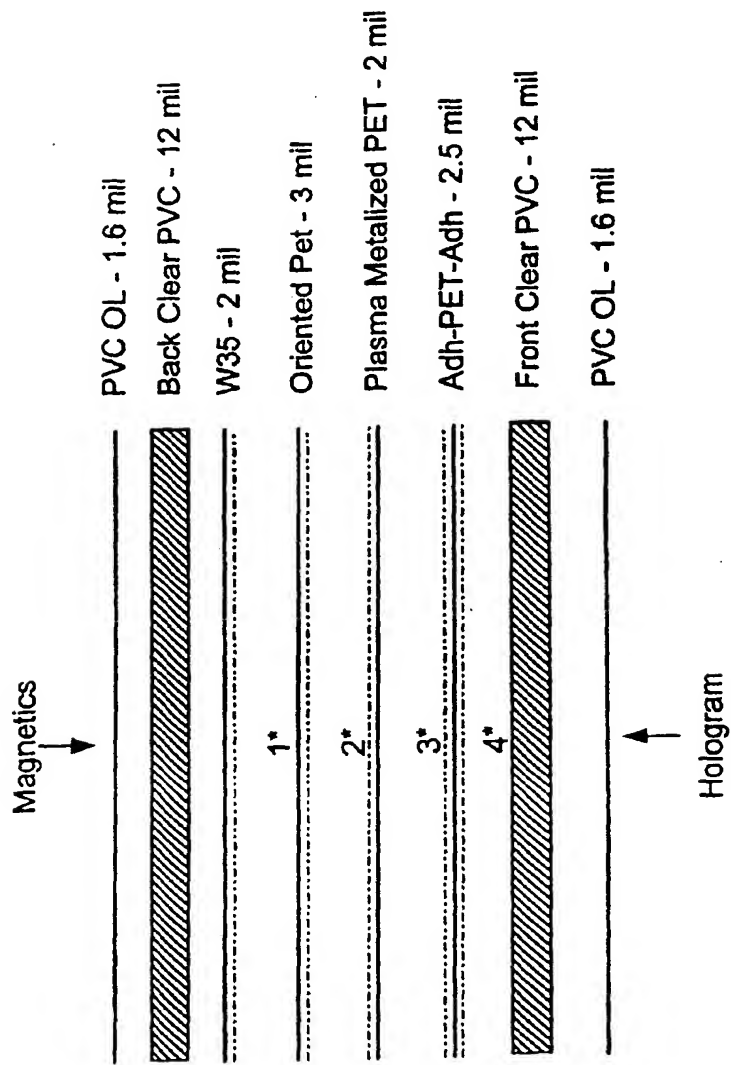


FIGURE 11D

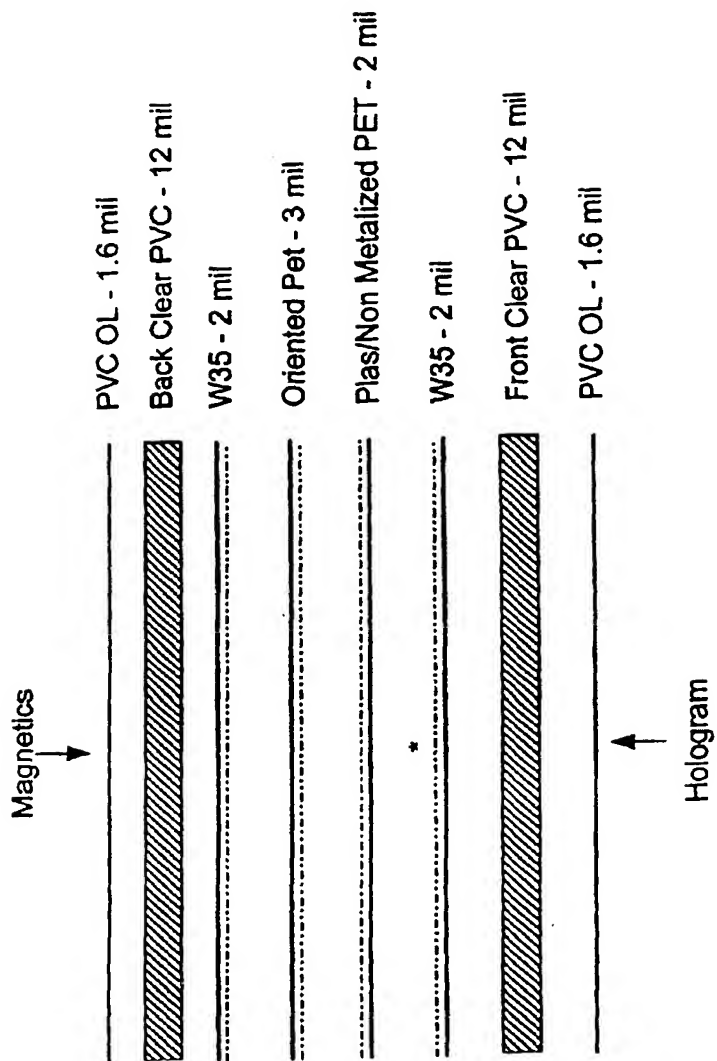


FIGURE 11E

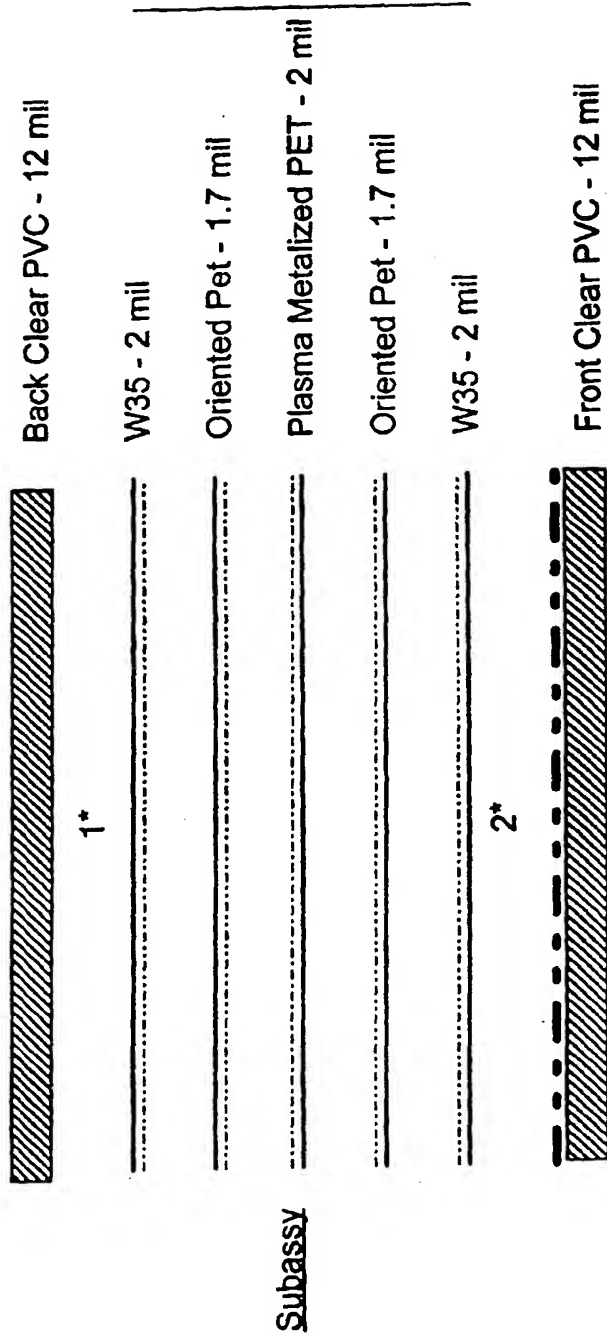


FIGURE 11F

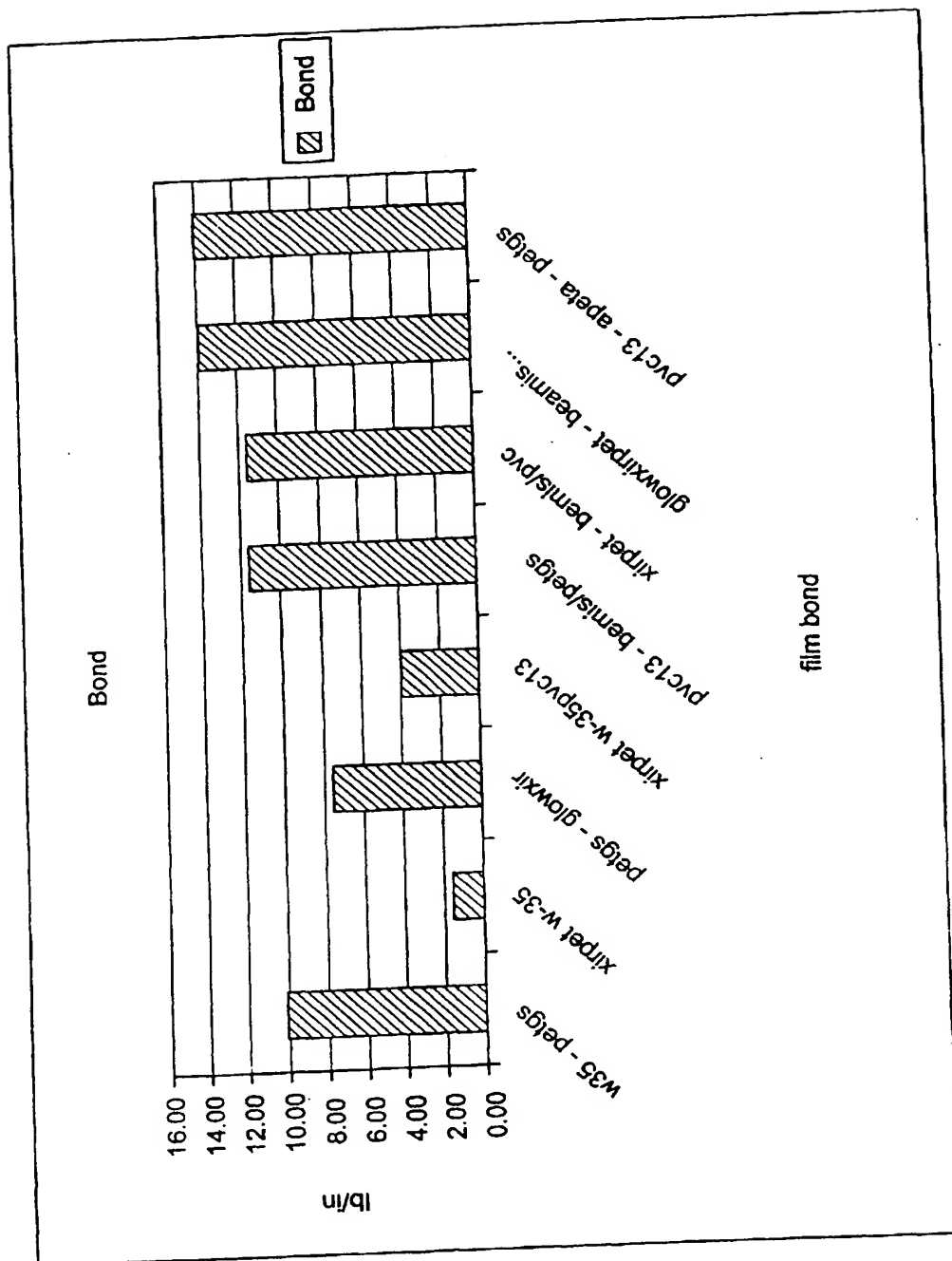


FIGURE 12A

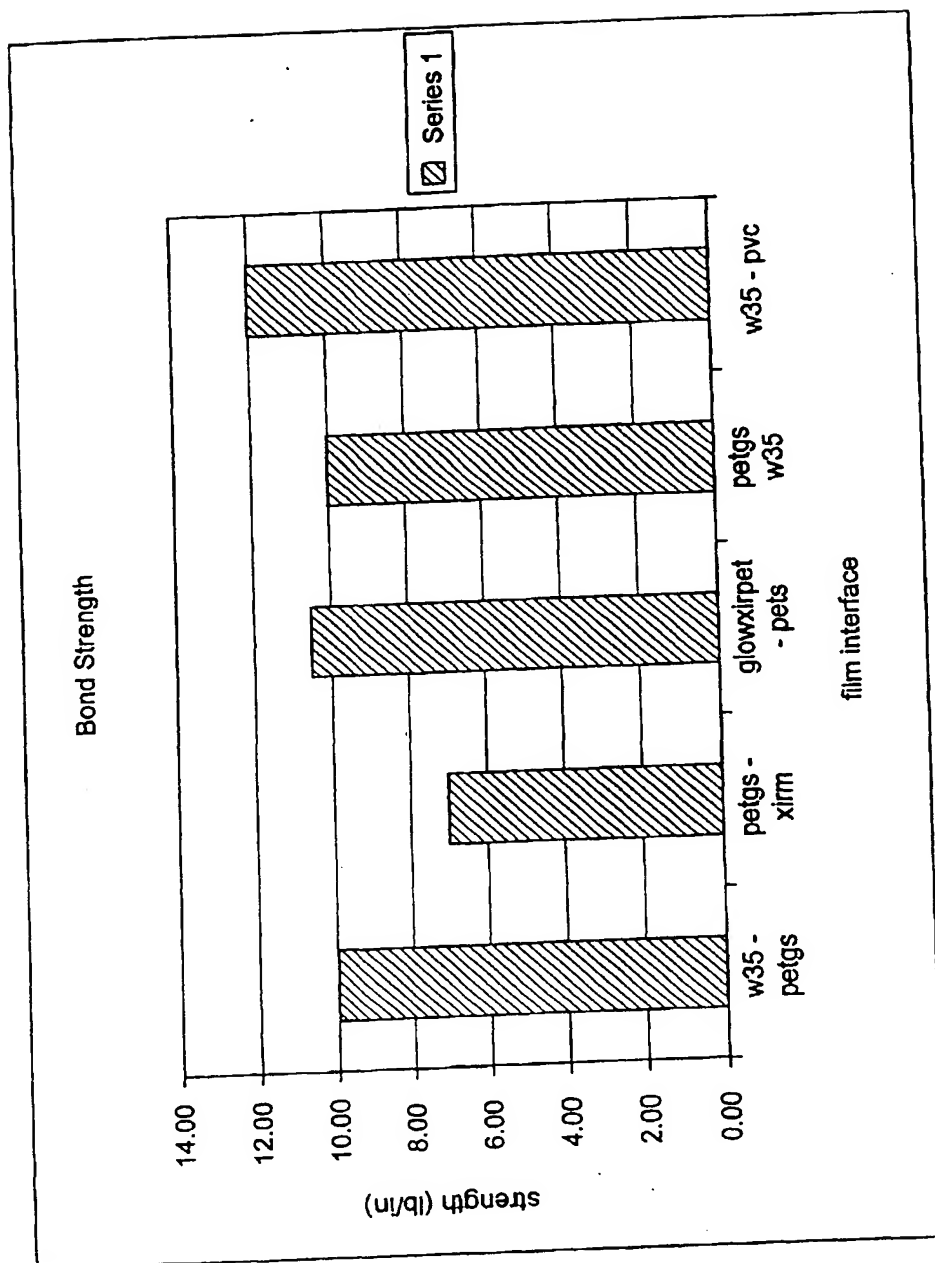


FIGURE 12B

Number	Material	Specifications	Source	Comments
	Construction 1 - white needs work, lamination temperature too low, pvc core			bond low.
1	pvc laminate	1.60	oberthur	front 4.1, 4.4; back 4.0, 4.0
2	pet adhesive both sides	2.50	allied signal	
3	printed core - white #1	12.00	oberthur	
4	printed core - white #1	12.00	oberthur	
5	wl-35 pvc (adh to xir)	2.00	klockner	
6	xir (metal to pet gs)	1.00	southwall	
7	pet glue/stamp	1.70	d & k	1.2 mil adhesive, 0.5 mil pet.
Total		32.80		thickness .030 - .031
	Construction 2			
1	pvc laminate	1.60	oberthur	
2	pet adhesive both sides	2.50	allied signal	
3	printed core	12.00	oberthur	
4	printed core	12.00	oberthur	
5	wl-35 pvc (adh to xir)	2.00	klockner	
6	xir (metal to pet gs)	1.00	southwall	
7	pet glue/stamp (adh to xir)	1.70	d & k	1.2 mil adhesive, 0.5 mil pet.
8	wl-35 pvc (adh to pet)	2.00	klockner	
Total		34.80		
	Construction 3			
1	pvc laminate	1.60	oberthur	
2	pet adhesive both sides	2.50	allied signal	
3	printed core	12.00	oberthur	
4	printed core	12.00	oberthur	
5	wl-35 pvc (adh to xir)	2.00	klockner	
6	xir (metal to pet gs)	1.00	southwall	
7	pet glue/stamp (adh to xir)	1.70	d & k	1.2 mil adhesive, 0.5 mil pet.
8	gomar pvc (adh to pet)	2.00	allied signal	
Total		34.80		
	Construction 4 - white #2 too dark, temperature too low, pvc lamination bond			low
1	pvc laminate	1.60	oberthur	front - 4.0, 4.3; back tear
2	pet adhesive both sides	2.50	allied signal	
3	printed core - white #2	12.00	oberthur	
4	printed core - white #2	12.00	oberthur	
5	bemis (adh to xir)	2.00	klockner	
6	xir (metal to pet gs)	1.00	southwall	
7	pet glue/stamp	1.70	d & k	1.2 mil adhesive, 0.5 mil pet.
Total		32.80		thickness .030 - .031
	Construction 5 - white #3 too dark, temperature too low - pvc lamination bon			low
1	pvc laminate	1.60	oberthur	
2	pet adhesive both sides	2.50	allied signal	
3	printed core - white #3	12.00	oberthur	
4	printed core - white #3	12.00	oberthur	
5	w-35 (adh to xir pet)	2.00	klockner	
6	xir (metal to pet gs)	1.00	southwall	
7	pet glue/stamp	1.70	d & k	1.2 mil adhesive, 0.5 mil pet.
Total		32.80		thickness .030 - .031
	howard 1.0 coating			
1	neocryl b725	33.60	zeneca?	
2	EtOH	31.20		
3	nPOAc	31.20		

FIGURE 13

	4 citraflex a4	4.00	moreslip, greensboro	
Total		100.00		
	construction #6 - seems to stick ok, best so far, scale up. Make sub-laminat			(aka - s)
	1 pvc laminate	1.60	oberthur	
	2 core pvc	12.00	oberthur	
	3 bemis	2.00	bemis	
	4 petgs	1.70	d & k	
	5 xir (metal to pet gs)	1.00	southwall	plasma treated
	6 bemis	2.00	bemis	
	7 core pvc	12.00	oberthur	
	8 pvc laminate	1.60	oberthur	magnetics
Total		33.90		
	herslow sublamination			
Total Price				
	construction #7- seems to stick ok, best so far, scale up. Make sub-laminat			(aka - t)
	1 pvc laminate	1.60	oberthur	
	2 core pvc	12.00	oberthur	
	3 w-35	2.00	bemis	
	4 petgs	1.70	d & k	
	5 xir (metal to pet gs)	1.00	southwall	plasma treated
	6 bemis	2.00	bemis	
	7 core pvc	12.00	oberthur	
	8 pvc laminate	1.60	oberthur	magnetics
Total		33.90		
	construction #7 - seems to stick ok, best so far, scale up. Make sub-laminat			(aka - t)
	1 pvc laminate	1.60	oberthur	
	2 core pvc	12.00	oberthur	
	3 w-35	2.00	bemis	
	4 petgs	1.70	d & k	
	5 xir (metal to pet gs)	1.00	southwall	plasma treated
	6 w-35	2.00	bemis	
	7 core pvc	12.00	oberthur	core to core = 14.2 lb.in.
	8 pvc laminate	1.60	oberthur	magnetics
Total		33.90		
	construction #8 - sublamine to be used with 12 mil pvc core			
	1 w-35	2.00		
	2 petgs	1.70		
	3 xir (metal to pet gs)	1.00		
Total		4.70		
	construction #9 - sublamine to be used with 10 mil pvc core			
	1 pvc laminate	1.60		
	2 w-35	2.00		
	3 petgs	1.70		
	4 xir (metal to pet gs)	1.00		
	5 bemis	2.00		
	6 pvc laminate	1.60		
Total		9.90		
	construction #10 (if u works)			
	1 w35	2.00		
	2 petgs	1.70		
	3 xir (metal to p l gs)	1.00		
	4 w35	2.00		

FIGURE 13 (Continued)

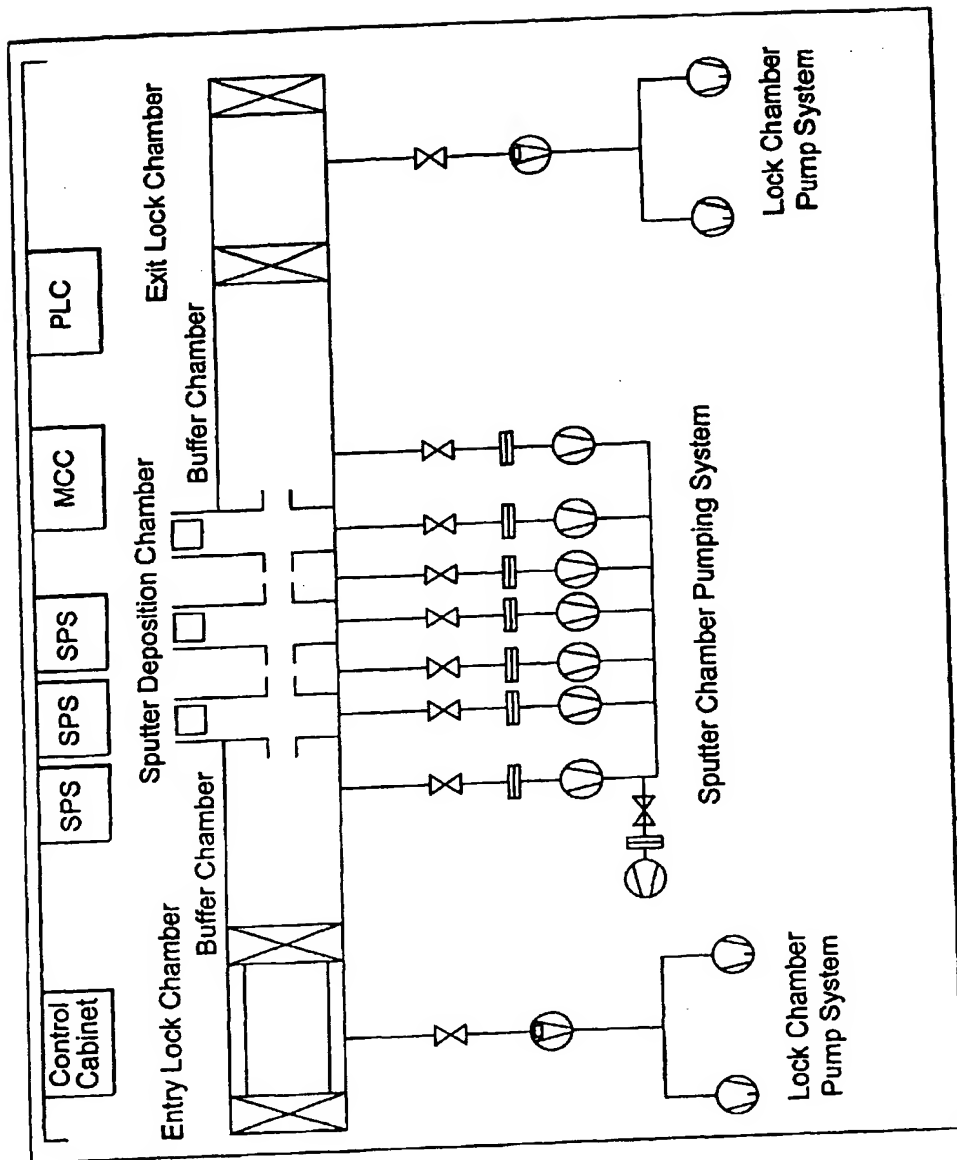


FIGURE 14

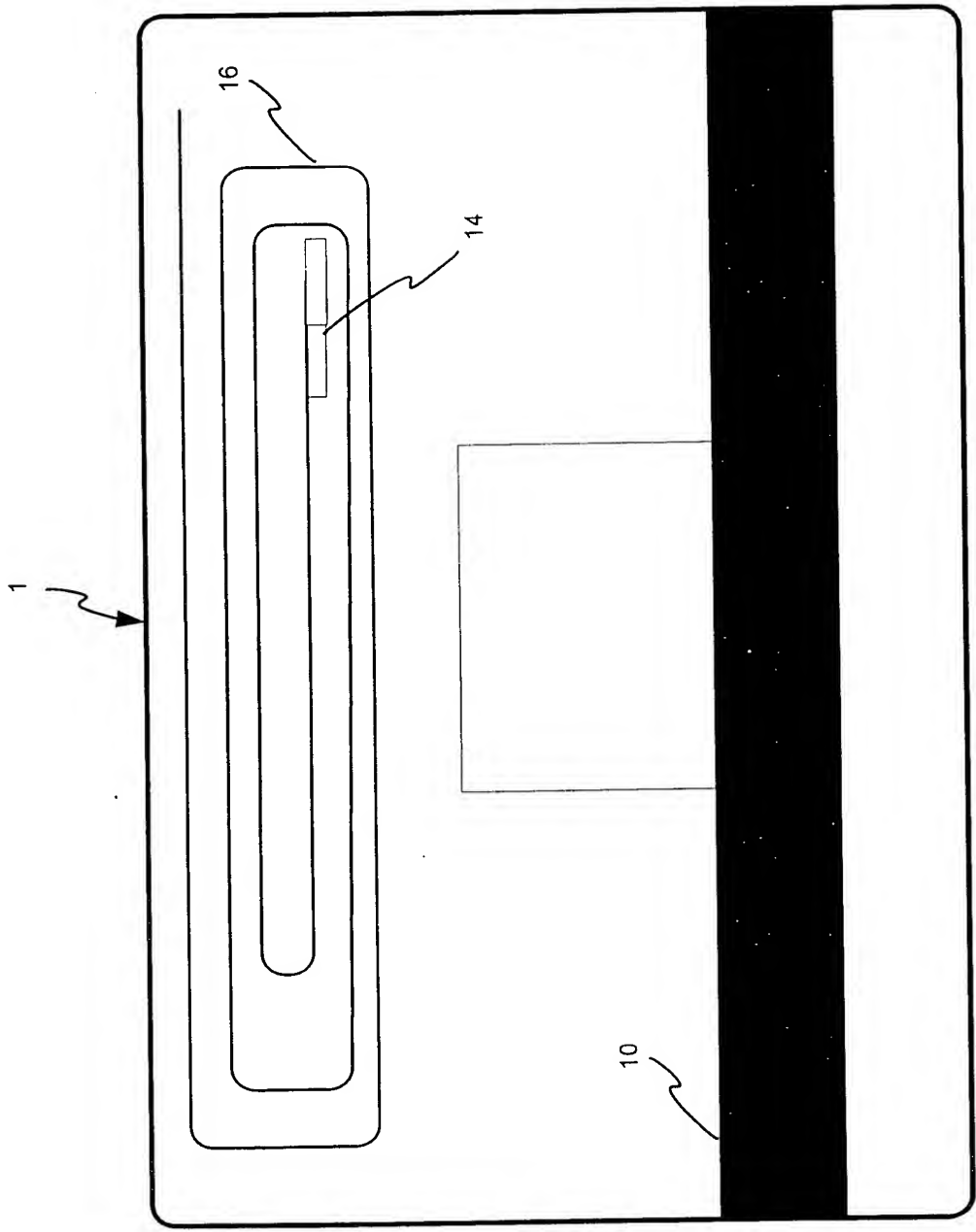


FIGURE 15A

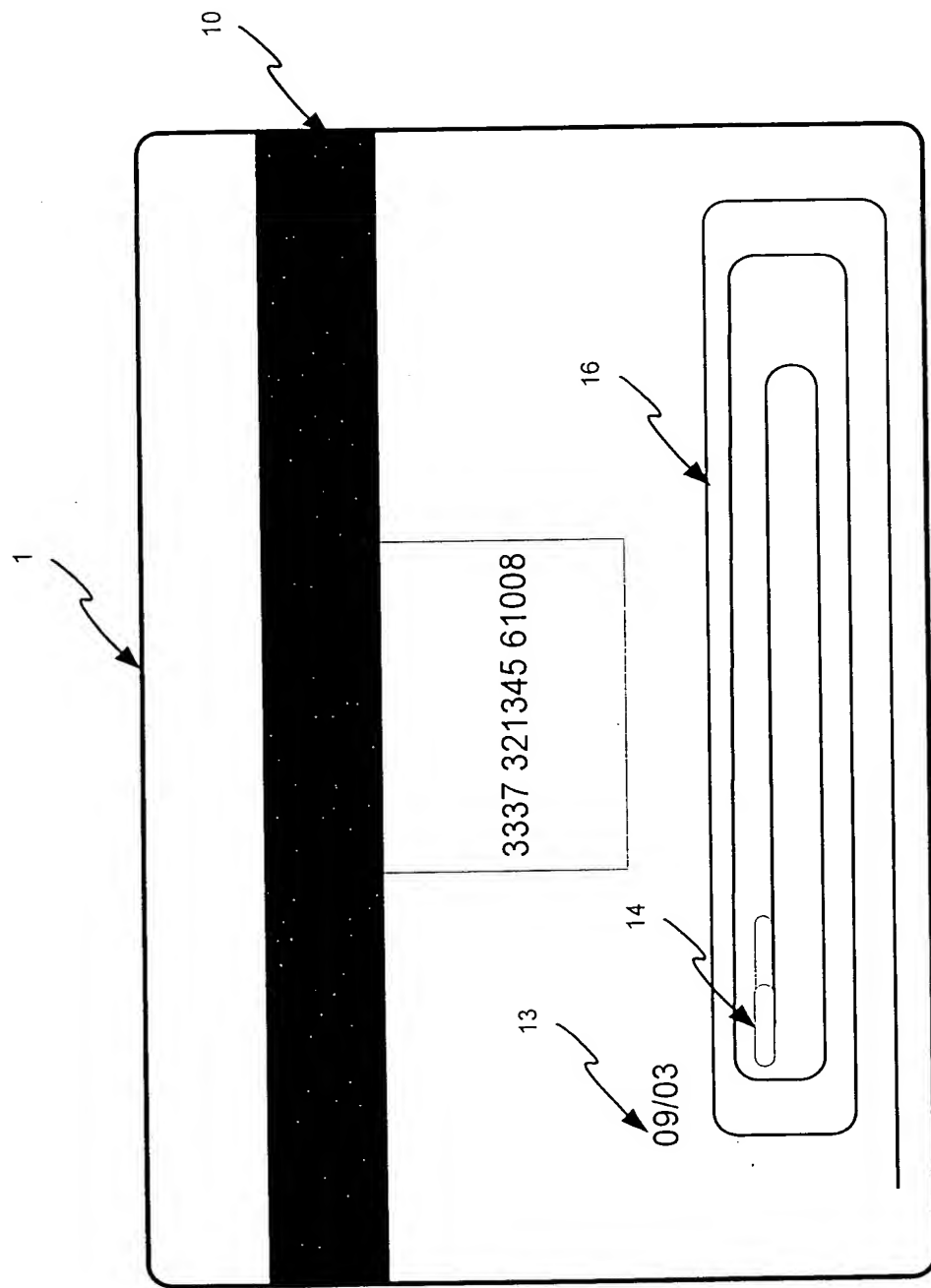


FIGURE 15B

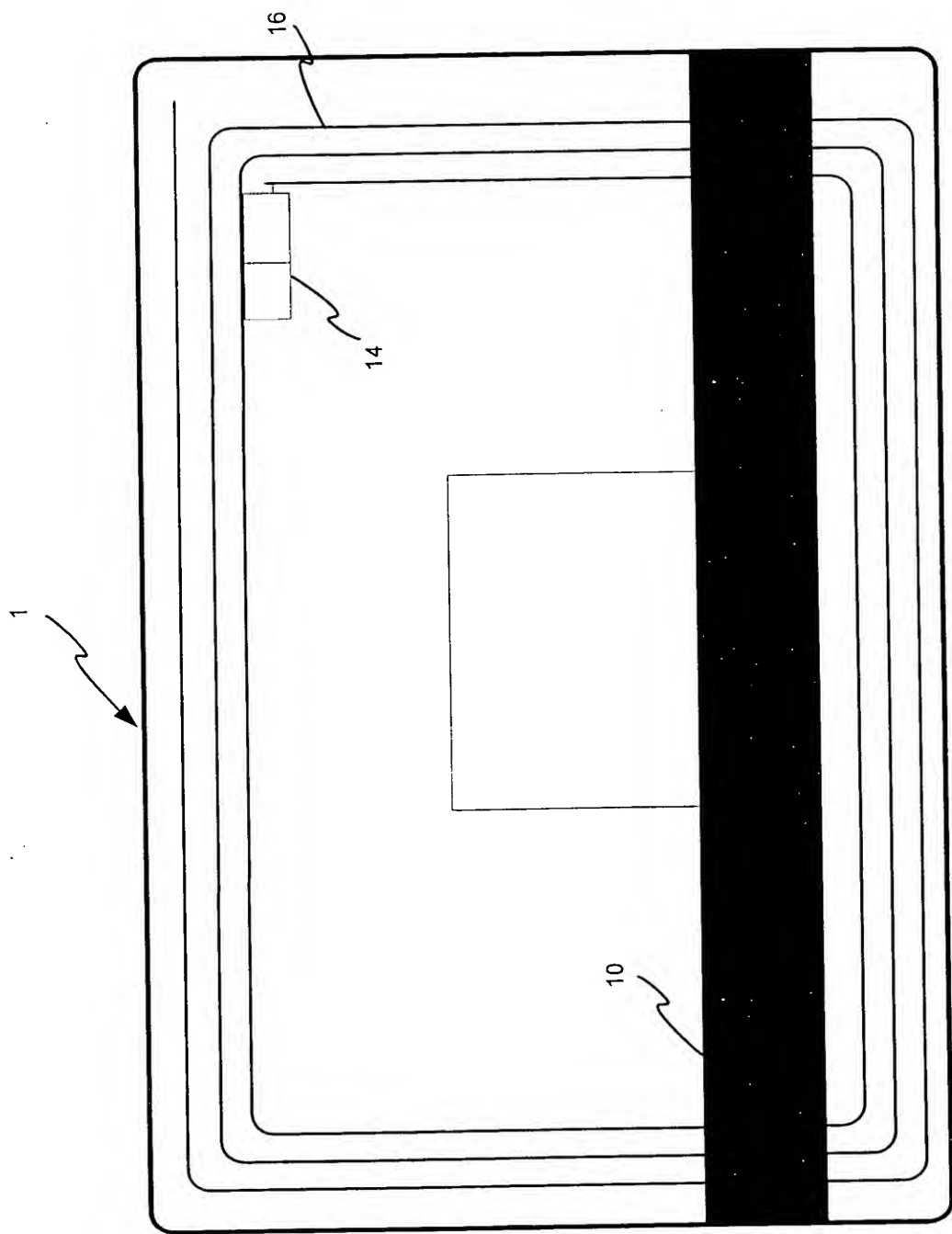


FIGURE 16

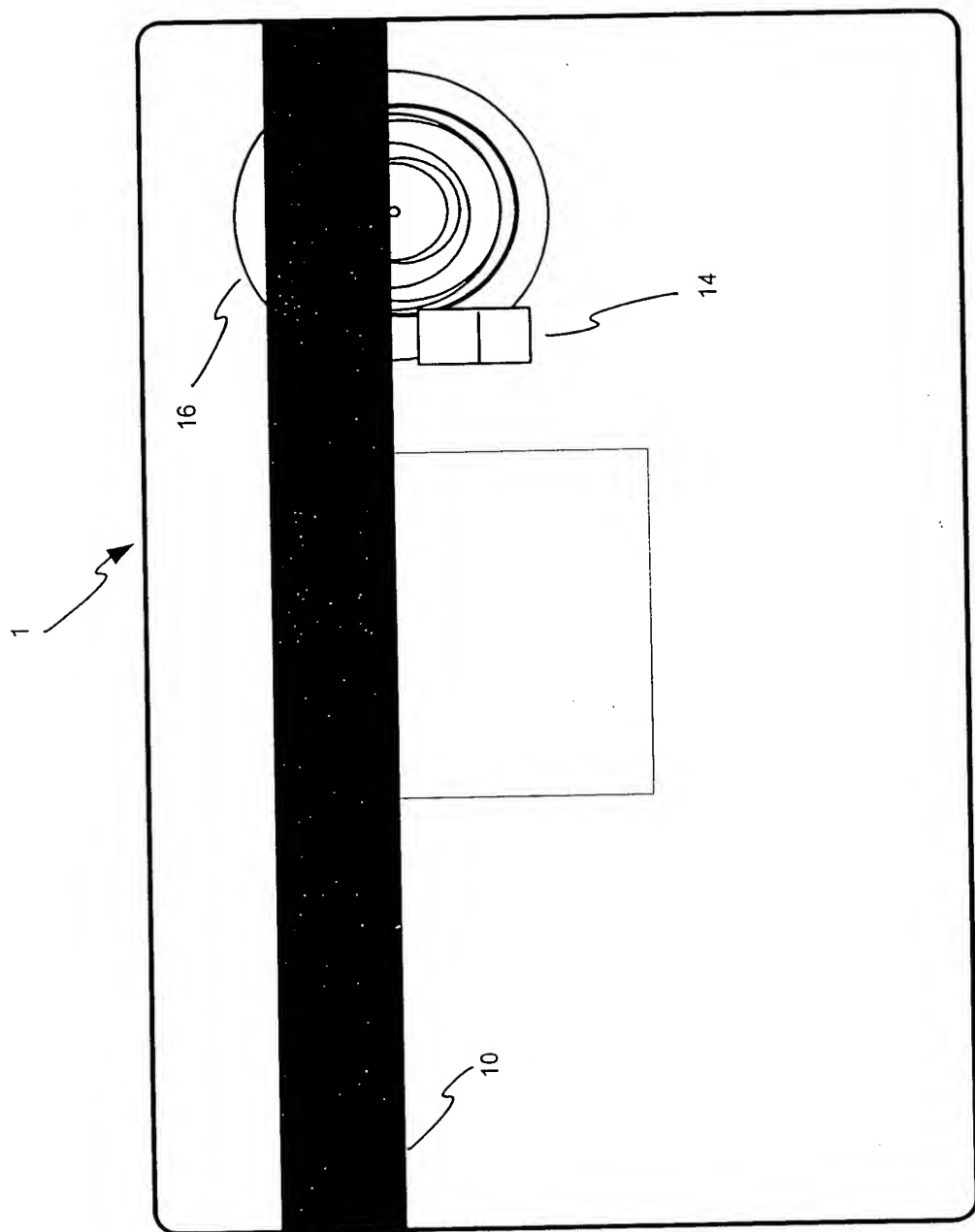


FIGURE 17

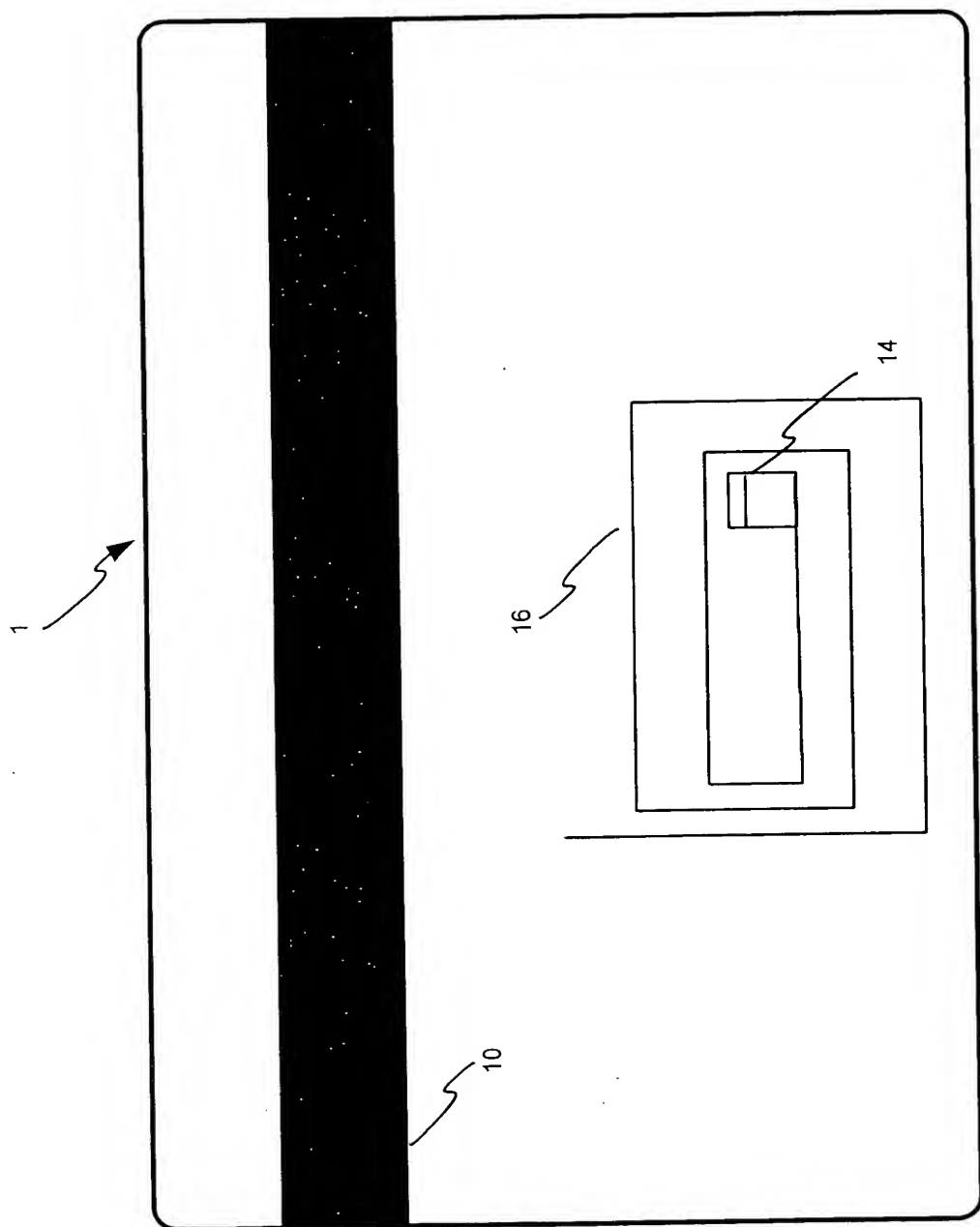


FIGURE 18